

Date: Thursday, 3/13/2008 10:18:59 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	BUSHING	
Job Number	37920			Part Number	D2570	
Estimate Number	10175			Drawing Number	D2570 REV B	
P.O. Number				Project Number	N/A	
This Issue	3/13/2008	S.O. No.	:	Drawing Revision	B	
Prsht Rev.	NC			Material		
First Issue	/ /	Type	MACHINED PARTS	Due Date	4/10/2008	Qty: (500) Um: Each
Previous Run	37748					398
Written By	<u>J</u>					
Checked & Approved By	<u>J</u> 080313					
Comment	Est E 02.08.29 Re-format; Removed finishing; Material changeK J est F 07.07.06 rev B dwg EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M303R0750	303 Round Bar .75"	
Comment:	Qty.: 0.0810 f(s)/Unit Total : 40.4775 f(s)		
	Material: Ø0.750 AISI 303 SS Rod (M303R0.750)	M105801	
	Batch M103077 M106633 M106292		SC 08/03/17 398
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
Comment:	HARDINGE CNC LATHE SMALL		
	Machine as per folio FA198		
	Deburr		SC 08.03.17 398
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		SC 08.03.17 398
4.0	QC8	SECOND CHECK	
Comment:	SECOND CHECK		SC 08/03/17 398
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment:	PACKAGING RESOURCE #1		
	Identify and Stock		
	Location: ST37		AS 08/03/17 X398

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:18:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 37920

Part Number: D2570

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(388)

Comment: FINAL INSPECTION/W/O RELEASE

DD 08/03/19

Job Completion



2008/3/17 388

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37920
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

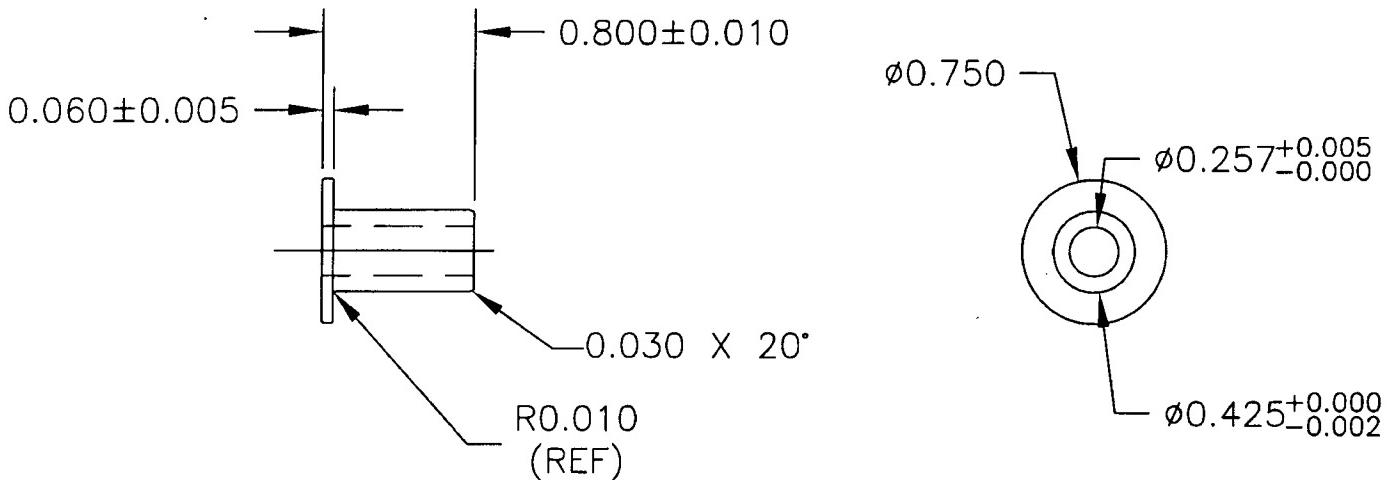
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	08-03-17	Date:	08/03/17	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	Z

DART

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
07.06.28 *[initials]***D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. *37920*

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